

Date: Monday, 09/03/2009 1:14:21 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D3690-1 GLARESHIELD
Job Number	: 46339		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: Z_CUSTOM
This Issue	: 09/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: PAINT SAMPLE
First Issue	: / /	Project Number	:
Previous Run	: 00015	Drawing Revision	:
	Type : R&D GENERAL	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: <u>MF 09-03-09</u>	Qty:	1 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

USE D3690-1 SCRAP PART TO TEST NEW PAINT FOR GLARESHIELD BEFORE APPLYING ON
 ORIGINAL PART

(Donyl has a scrap part of same material)

2.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

SCUFF LIGHTLY TO REMOVE EXISTING PAINT

3.0	SPRAY PAINTING	SPRAY PAINTING
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Comment: SPRAY PAINTING

Plastic cleanser M111071
adhesion promoter M111071

Eng.
Primer Filler M111071
hardener 929-53 M111071
Reducer 352-50 M110997

urethane acrylic M111113
hardener 929-91 M111113
Reducer M110997

IT 09-03-10

4.0	QC14	INSPECT SPRAY PAINT
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Comment: INSPECT SPRAY PAINT

09-03-11 (1)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

MF 09-03-17

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: March 5, 2009 4:39 PM
To: 'Peter Hum'
Cc: 'L Lacelle'
Subject: FW: Raw Plastic Prep

For the QSL... we NEED to use 20 % reducer since this is what we did on the testing.

David

From: Shane Wikene [mailto:paintshop@eaglecopters.com]
Sent: Thursday, March 05, 2009 11:36 AM
To: 'L Lacelle'
Cc: dshepherd@dartaero.com
Subject: RE: Raw Plastic Prep

Linda,

Just a heads up on mixing the paint, the reducer percentage will affect the gloss levels as well as the amount of paint put on the dash, so a 10% ratio will be less coat of application but the gloss level will be higher, if 20% reducer is added the amount of coats will increase but the gloss level will lower.....

Shane Wikene

*Eagle Copters
Calgary AB
Refinishing Shop Manager
403-250-7370 Ext 150*

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, March 05, 2009 11:34 AM
To: 'Shane Wikene'
Cc: dshepherd@dartaero.com
Subject: RE: Raw Plastic Prep

THANKS

From: Shane Wikene [mailto:paintshop@eaglecopters.com]
Sent: March 5, 2009 1:21 PM
To: llacelle@dartaero.com
Cc: dshepherd@dartaero.com
Subject: Raw Plastic Prep

Raw plastic preparation:

Using a red scotch brite pad scuff the entire panel
Then using part # 541-30 plastic cleaner and a lint free towel, wipe the entire part to be painted clean.
After the panel has been cleaned you will spray 2 med/ wet coats of part # AM865 plastic adhesion promoter

06/03/2009

Allow the adhesion promoter to flash off for 20 mins

Now you will have to apply a plastic primer/sealer, part # 285-60, mixed with 929-53 and 352-50 reducer at a ratio of
2 parts primer/sealer, 1 part 929-53, 30% 352-50 reducer

Allow primer/sealer 20 mins to flash before topcoating

Your flat black will require 3 coats for complete coverage.

Black paint will be mixed at 3 parts paint 1 part 929-91 hardener ~~10%~~ 352-50 reducer

20%

09.03.06

If you have any more questions feel free to contact me

Shane Wikene

Eagle Copters

Calgary AB

Refinishing Shop Manager

403-250-7370 Ext 130

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Version: 7.5.557 / Virus Database: 270.11.3/1985 - Release Date: 3/5/2009 7:54 AM

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Version: 7.5.557 / Virus Database: 270.11.8/1985 - Release Date: 3/5/2009 7:54 AM